

**Work Order ID 70464**

Thursday, June 09, 2011 7:42:37 AM



Page 1

Item ID: D3536-21

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 6/9/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

B11-6-9

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-9

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S wlog log

(12)

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Page 2

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Start Date: 6/9/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								
	Memo	0.00							

6/9/11 (12)

11/10/13  
ME  
11-06-10

# Picklist Print

Thursday, June 09, 2011 7:42:34 AM

Page 1

Work Order ID: 70464

Parent Item: D3536-21

Parent Item Name: Gasket



Start Date: 6/9/2011

Required Date: 6/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	100.6800	0.8503	11.33733			
NEOPRENE SHEET 0.063													

B11-G-9

Location

Loc Qty

Loc Code

MAT052

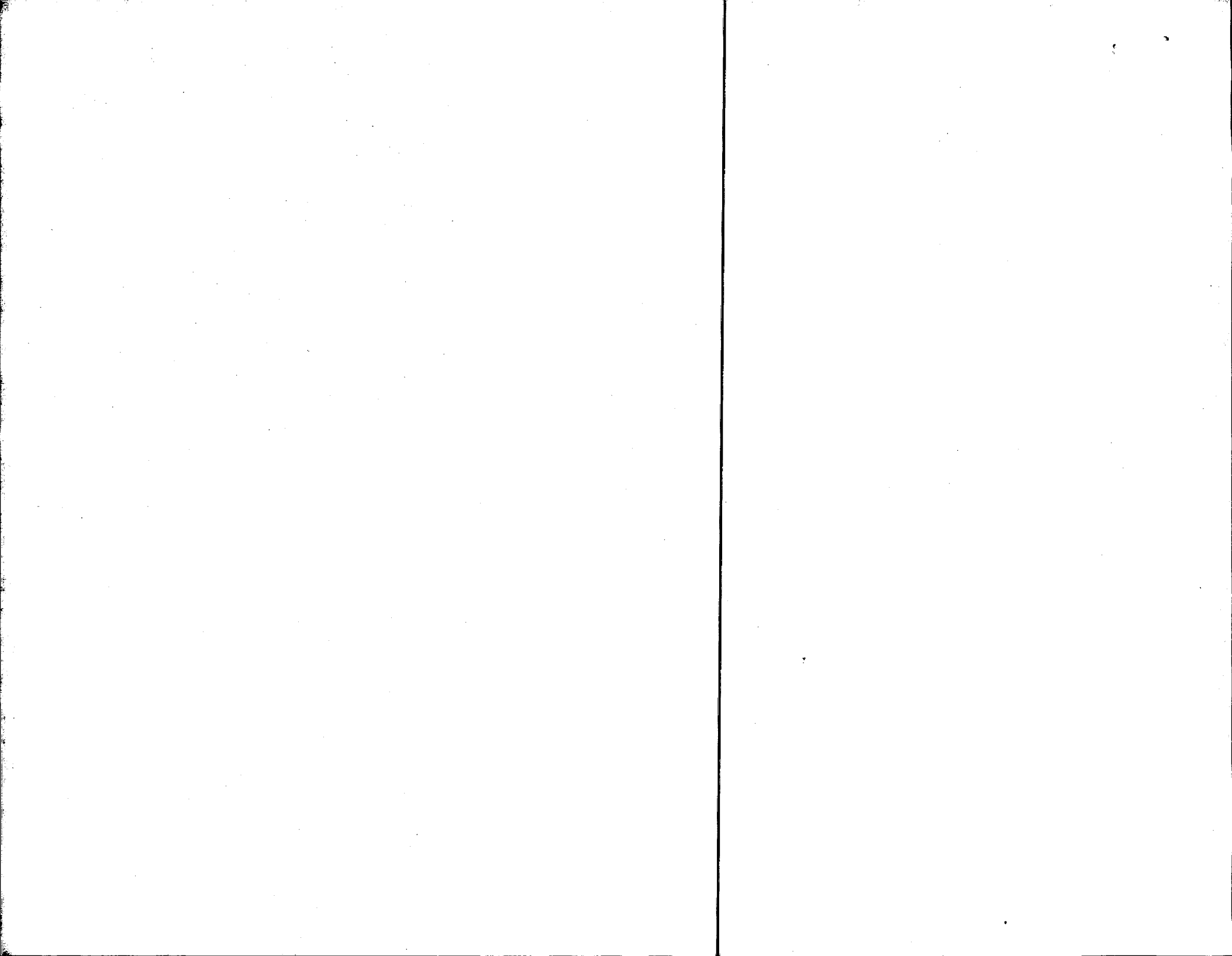
100.68

117295

100.68

117295

12



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>30464</i>
<b>Description:</b> Gasket		<b>Part Number:</b> D3536-21
<b>Inspection Dwg:</b> D3536	<b>Rev:</b> A	<b>Page</b> 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.70	+/-0.030	32.70	✓		T	
27.25	+/-0.030	27.25	✓		T	
21.80	+/-0.030	21.80	✓		T	
16.35	+/-0.030	16.35	✓		T	
10.90	+/-0.030	10.90	✓		T	
5.45	+/-0.030	5.45	✓		T	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
6.00	+/-0.030	6.00	✓		T	
2.00	+/-0.030	2.00	✓		T	
0.90	+/-0.030	0.903	✓		V	
0.30	+/-0.030	0.305	✓		V	
0.30	+/-0.030	0.302	✓		V	
1.89	+/-0.030	1.888	✓		V	
Ø0.19	+0.004/-0.001	0.190	✓		V 002	

<b>Measured by:</b> <i>IB</i>	<b>Audited by:</b> <i>S</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-6-9	<b>Date:</b> 11/6/69	<b>Date:</b>	N/A

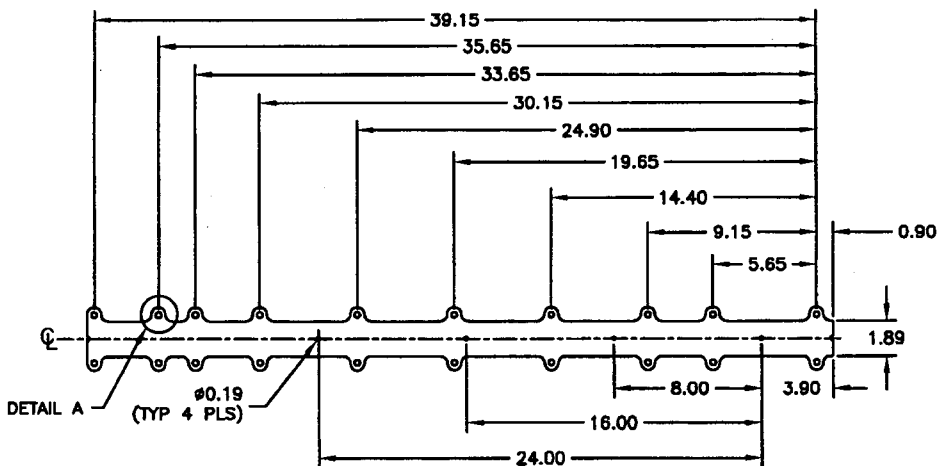
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD <i>AF</i>	<i>DB</i>

**DART**

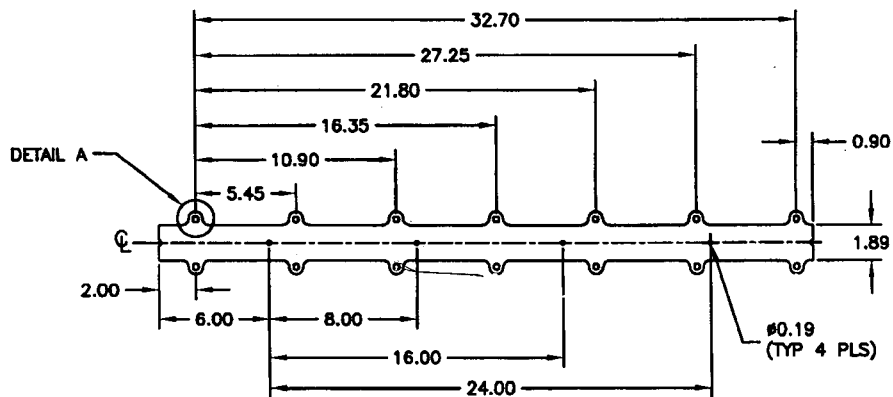
DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 2 OF 6
				SCALE 1:10

RELEASED  
070212

also 70464



**D3536-15 GASKET**



**D3536-21 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION